Work Order Wednesday, June O	· ID 120084 04, 2014 2:55:24 PM		*120))))))						Page 1
Revision ID:	03536-25 easket Center	A	Accept	*N900	040	100)* s	Setup Sta	171	S1* S2*
,	/04/14 Start Qty: 12.00	• *		Cust Item Customer:	ID:				· "N	ラン ^
7.7	Process Plan: <u>M</u> しづ QC:	Date: 14-06-05	Tooling: _ SPC (Y/N):		ate:	<u> </u>	R	tun Sta Sto	^ \	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3536	Rev A									
*1 \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	FLOW WATER JET Memo 1-Cut as po Deburr if n		0.00 0.00 Ω Prog Rev: <u>Γ</u>	2-			12		M	14/06/
110 *110* QC Quality Control	QC2- Inspect parts off t	machine FAI/FAIB	0.00						_ <u></u>	<u> 14/06/11</u>
120 *1 2 0* QC	QC8- Inspect parts - se	cond check	0.00 <u>IB</u> 14/6/	(,SM			(1Z)			

Quality Control

DISPOSITION Rework Scrap Water Jet Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Quality Thermoforming Composite Sign & Sign & Other Step Qty Prod. Eng. Coor. Quality Thermoforming Composite Sign & Sign & Sign & Supplier Prod. Eng. Coor. Quality Thermoforming Composite Sign & Supplier Prod. Eng. Coor. Quality Thermoforming Composite Sign & Supplier Prod. Eng. Coor. Quality Thermoforming Composite Sign & Supplier Prod. Eng. Coor. Quality Thermoforming Composite Sign & Supplier Prod. Eng. Coor. Quality Thermoforming Composite Sign & Supplier Prod. Eng. Coor. Quality Thermoforming Composite Prod. Eng. Coor. Quality Thermoforming Coor. Thermoforming Co	DQA:			Date:		-								~DART
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Part No. Skid-tube Skid-	1						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part No. Scrap Use as-is Suspected Unapproved Use as-is Use as-i	Work Orde	er: _					_				_	¬		¬ ₋
NCR No. Suspected Unapproved Suspected Unapproved Unapproved Unapproved Suspected Unapproved Una							l 			⊢	<u> </u>	-	—	
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Root Cause Date Step Qty Description of work order update or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling Handling/Pre Absterial Description Handling/Pre Absterial Description Description Date Verification QC Inspector Material Deperator Description Description Date Verification QC Inspector FAULT CATEGORY Landing Gear General Dending Description Date Verification D	ALCD A						<u></u>		inern	~ 	~ -	Rec/Stol		
Date Step Qty	Suspected Shapproved							Large Fab	Composite		3appliei [
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Doc/Oata	Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
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Turning Sequence Out of Calibration					-		-							
			-				╡					-		
Wave/Twist in Tube Fit/Function Out of Sequence		\Box					Fit/Function		4					

Work Orde Wednesday, June				*120	NA4*						Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3536-25 Gasket Center 6/04/14 6/04/14	Start Qty: 12.00 Req'd Qty: 12.00	*12 *13		*N900 Cust Item I		100)*	-		NS1* NS2*
Reference: Approvals:	Process Pla		Date:	Tooling:	D:	ate:	-	F		tart *	NR1*
Sequence ID/ Work Center II 130 *120* Packaging Packaging	QC:	Operation Description Identify as per dwg & Sto	Date:	SPC (Y/N): Set Up/ Run Hours 0.00 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	*	

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

140

Quality Control

MUS 14-06-12

DQA:			_ Date:				_						DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UF		ork Order up	date only	AEROSPACE
						DISPOSITION				AGAINST DI	PARTMENT	PROCESS	
Work Orde	er:					Dawe et l			Skid-tube	Crosstube	٦	Water Jet	Engineering
Part N	ما					Rework Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
Pailiv	¥U. -				—	Use-as-is			noforming	Finishing	-1	e/Packaging	Other
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Root					Desc	ription of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty	,	or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design													
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Operator			ļ										
Offset/Setup								÷					
Process													
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		Heat Tre				Cut Too Short		Mislabe			Power Loss/	Surge	Other
		4	n Strip in	Tube		Drawing		Misrea	d				
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		Turning S	Sequence			Finish		Out of	Calibration				
		Wave/Tv	vist in Tub	e		Fit/Function		Out of	Sequence				

Page 1

Work Order ID: 120084

120084

Parent Item:

D3536-25

D3536-25

Parent Item Name: Gasket Center

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	707.9900	0.5956	7.941334			
*MNFO60 NEOPRENE SHEET 0.063									**			mm	17/06/
				Location		Loc	<u>Oty</u>	Loc Code					
				MAT052		70	7.99						

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12.29

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M126546

M128266

(M128339)

DQA:			Date:				_		DA44105 / 11DD 41				DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDA		ork Order up	date only	AEROSPACE
		<u>-</u>				DISPOSITION			A	GAINST DE	PARTMENT,	PROCESS	
Work Orde	er: -				<u> </u>	Payrank	1		Skid tubo	osstube	1	Water Jet	Engineering
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Paitiv	··· -					Use-as-is			~ — —	inishing	4	e/Packaging	Other
NCR N	lo.					Suspected Unapproved		111011	· —	mposite	1	Supplier	1
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Root					Desc	ription of work order update		nitial	Action		Sign &		
Cause	ļ	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector
Design								_					
Doc/Data													
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	_	Crushing Countersink		4		4	gned/off center	" <u> </u>	Positioned V	 Vrong			
	Heat Treat Cut Too Short				Mislab		·	Power Loss/		Other			
	_	Inspectio		Tube		Drawing		Misrea			_		
; 	_	Marks/Chatter Drill Holes				Off-set							
				Finish		4	Calibration	1					
	—	Wave/Tw				Fit/Function	İ	-	Sequence				

DART AEROSPACE LTD	Work Order:	120084
Description: Gasket	Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1

	X	First Article	F	rototyp	e	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	2180	/		T. Jun-06	
16.35	+/-0.030	16.35	/			
10.90	+/-0.030	10.90				
5.45	+/-0.030	5.45				
6.00	+/-0.030	6.00				
6.75	+/-0.030	6.75				
12.75	+/-0.030	12.75	/			
1.89	+/-0.030	1.89				
0.30	+/-0.030	0.30				
0.30	+/-0.030	0.30	/			
Ø0.19	+0.005/-0.001	0.19				
	·					

Measured by:	Audited by:	EB.		Prototype Approval:	N/A
Date: 14/06/11	Date:	14/6/	//	Date:	N/A
17/06/11	L	, 42. /			

			Povised by	Approved
Rev	Date	Change	Revised by	
A	07.06.13	New Issue	KJ/JLM CX	

DATE 06. \triangleright

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AEROSPACE PORT HADLOCK,

USA,

RC.

D3536 DRAWING NO.

SHEET

1 OF 6

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NEW

ISSUE

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D3536-11 GASKET

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PURPOSE

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COPIED

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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AEROSPACE PORT HADLOCK,

USA,

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2 OF 6

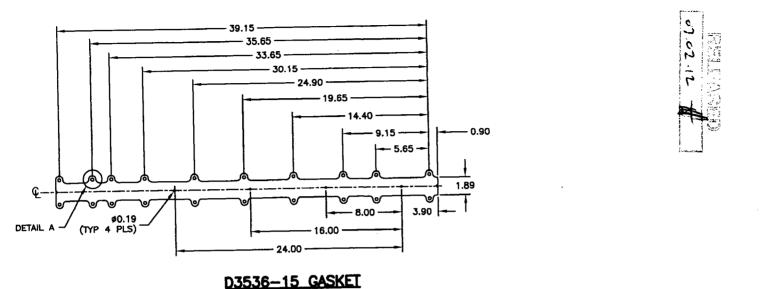
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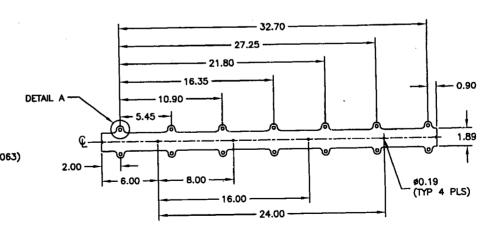
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06.10.25

GASKET





D3536-21 GASKET

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4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION

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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF. DART SPEC. M—NEO60—S.063)	
2) FINISH: NONE 3) PART IS SYMMETRICAL ABOUT & 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED	٦

5) ALL DIMENSIONS ARE IN INCHES 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

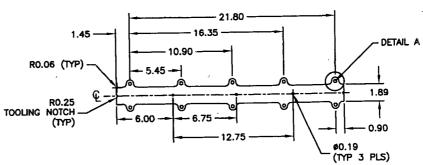
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PURPOSE

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06.10.25 B APPROVED क्रि श D3536 GASKET

DRAWING NO.

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07,02.12 21.00

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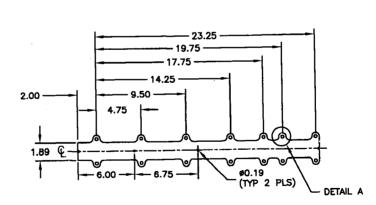
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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT €.
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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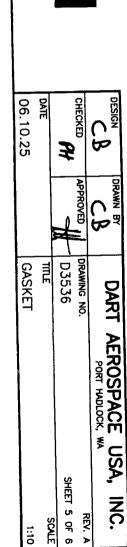
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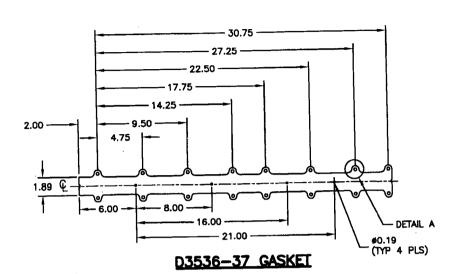


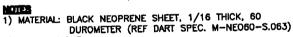
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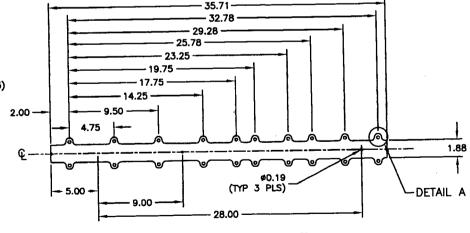


2) FINISH: NONE

3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES
IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



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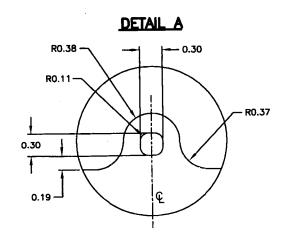
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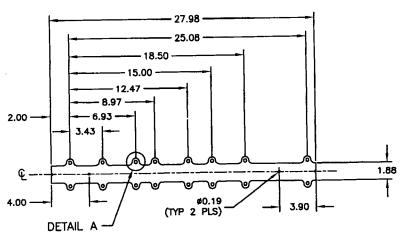
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D3536-41 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE

 3) PART IS SYMMETRICAL ABOUT &
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER